



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D2666-2

Job Sheet 199307



Part No: D2666-2

Job Qty: 4 pcs

Part Name: Saddle, RH, Fwd, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/16/19

Job Tracking No:

Due Date: 9/6/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D
07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	9/6/19		1.00	4.00	HAAS - 1		SBL 19/09/11
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	9/6/19		0.00	0.62	Conventional Mill - 1 - B4B		VHJ 19/9/13
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	9/6/19		0.00	0.00	QC 2 - 1		VHJ 19/9/12
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



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Container No: S212738



Part: D2666-2

Job No: 199307

Serial No/Batch: S212738

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/11/19

Plex 8/16/19 3:29 PM Dart.lajeunesse.marie

				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130	QC 8	4	9/6/19	0.00 0.00	QC 8 - 12
		pcs			QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
140	Handfinish - 1-1 Chemical-B4B	4	9/6/19	0.00 0.47	Handfinish - 1 - 1 - B4B
		pcs			Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B
					Handfinish - 1 - 21 - B4B
					Handfinish - 1 - 22 - B4B
150	Powdercoat - 1 White G(A)-	4	9/6/19	0.00 0.14	Powdercoat - 1 - B4B

19/09/16

DAS
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B4B M193459		pcs			Powdercoat - 2 - B4B	
START: 7:25 O.T. 3:00 FINISH: 7:55					Powdercoat - 3 - B4B	34 19-9-18
160 QC 3		4	9/6/19	0.00 0.00	Powdercoat - 4 - B4B	
		pcs			QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170 Packaging 3-1 - Stock - B4B		4	9/6/19	0.00 0.00	Packaging 3 - 1 - B4B	
		pcs			Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	

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PC ST401

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	4 pcs	9/6/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	SEP 24 2019 70
				QC 21 - SA - 53	9-89

Part Op 100 - HAAS CNC Vertical Machine - Program batch number. 1-Inspect part number and batch number are programmed
 Descriptions: correctly. 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of
 Folio and visually inspect as per attached Dimension Sheet 6
 110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) - START TIME: _____
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 pcs (1 ea)	100-HAAS 4 Axis	5185 569 <i>5184 644 x1</i>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-001	4	53	0

Part Specifications
Specifications could not be found.

Plex 8/16/19 3:29 PM Dart.lajeunesse.marie

DART AEROSPACE LTD				Work Order: 199307	
Description: 206 Saddle, Inboard, Right side				Part Number: D2666-2	
Inspection Dwg: D2666 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.120	.120	.120	.120	
B	0.100	0.140		.125	0.125	0.124	0.125	
C	2.470	2.510		2.445	2.445	2.445	2.445	
D	0.100	0.180		.132	0.135	0.135	0.135	
E	0.210	0.230		.222	.222	.222	.222	
F	1.313	1.343		1.323	1.323	1.323	1.323	
G	0.240	0.260		.255	0.252	0.253	0.253	
H	0.615	0.685		.650	.650	.655	.650	
I	1.125	1.145		1.135	1.135	1.135	1.135	
J	0.990	1.010		1.000	1.000	1.002	1.002	
K	0.235	0.240		.238	0.238	0.238	0.238	
L	0.510	0.515		.510	0.510	0.50	0.510	
M	0.100	0.120		.110	0.110	0.110	0.110	
N	1.565	1.585		1.575	1.575	1.575	1.575	
O	5.990	6.010		6.001	6.003	6.003	6.003	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.490	0.510		.498	0.496	0.500	0.502	
S	0.312	0.318		.313	0.3125	0.3125	0.3125	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.315	0.322		.316	.316	.316	.316	
W	0.540	0.560		.550	0.550	0.550	0.550	
X	1.674	1.684		1.680	1.674	1.674	1.674	
Y	0.256	0.262		.257	.257	.257	.257	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: SBL / JAB	Date: 19/9/12
Audited by:	Date:
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added-Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension S and Y revised	KJ	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐							
Date :	Sequence #:	QTY Affected :		MRB (QSID42)							
Description Work Order Deviation				Disposition							
				Completed By							
				Lead hand / Supervisor							
				QC / QA Coordinator							
Root Cause		FAULT CATEGORY									
Operator ☐		Pressure/Forced ☐		Contamination ☐		Power Loss/Surge ☐		Positioned Wrong ☐			
Manufacturing Process ☐		Bending ☐		Misaligned/off center ☐		Folio/Program ☐		Outside Tolerance ☐			
Equip/Tooling ☐		Crushing ☐		BOM/Route ☐		Grain Direction ☐		Drawing ☐			
Handling/Preservation ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Finish ☐			
Material ☐		Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐			
Product Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Out of Sequence ☐		Misread ☐			
Process Improvement ☐		Mislabeled ☐		Fit/Function ☐		Off-set/Set-up ☐					
Human Factors ☐		Other/Details:									